

Note: For the full product names of the 3M products listed on this page, please see page 1.

Shelf Life and Storage

- 3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 has a shelf life of one year.
- Storage conditions (new and partially used rolls). For optimum performance, use the middle of these ranges:
 - Original packaging, including plastic wrap
 - Relative humidity of 20% to 80%
 - Temperature of 33° to 104°F (0° to 40°C)
 - Away from direct sunlight
- Do not stack unprotected rolls or lay sharp or heavy objects on them.

Health and Safety

⚠ Caution

When handling any chemical products, read the manufacturers' container labels and the Material Safety Data Sheets (MSDS) for important health, safety and environmental information.

To obtain MSDS sheets for 3M products:

- By fax, call 1-800-364-0768 in the US and Canada or 1-650-556-8417 for all other locations.
- Electronically, visit us at <http://www.3M.com/msds>.
- By mail, or in case of an emergency, call 1-800-364-3577 or 1-651-737-6501.

When using any equipment, always follow the manufacturers' instructions for safe operation.

Warranty and Limited Remedies

3M™ MCS™ Warranty for Graphics Produced on HP DesignJet Printers and Epson Stylus Pro Printers

The following is made in lieu of all other express or implied warranties, including any implied warranty of **merchantability** or fitness for a particular purpose: We warrant graphics produced by a 3M Ink Jet Registered Fabricator made with imaging media 8522, printed on an approved HP thermal ink jet printer according to HP's recommendations or Epson Stylus Pro printer according to Epson's recommendations, overlaminated with 8519 or 8520, and applied to a Warranted Substrate according to 3M's recommendations. These



Commercial Graphics Division
 3M Center, Building 220-6W-46
 PO Box 33220
 St. Paul, MN 55133-3220 USA
 General Info: 1-800-374-6772
 Technical Info: 1-800-328-3908
 Fax: 1-651-736-4233
 Fax-on-Demand: 1-800-364-0768 / S/Canada or 1-651-732-6506 International
 Fax-on-Demand document: 4506
www.scotchprint.com

3M Canada
 P.O. Box 5757
 London, Ontario
 Canada N6A 4T1
 1-800-265-1840
 Fax: 519-452-6245

3M México, S.A. de C.V.
 Av. Santa Fe No. 55
 Col. Santa Fe, Del. Alvaro Obregón
 México, D.F. 01210
 52-55-52-70-04-00
 Fax: 52-55-52-70-22-77

3M Puerto Rico, Inc.
 Puerto Rico Industrial Park
 P.O. Box 100
 Carolina, PR 00986-0100
 787-620-3000
 Fax: 787-750-3035

graphics are covered against failure caused by ultraviolet light, temperature extremes, pollution, and other elements.

If a graphic fails to perform in accordance with 3M product specifications within this time frame, 3M will replace the materials at no charge. **These remedies are exclusive. In no case shall 3M be liable for any direct, indirect, or consequential damages, including any labor charges.**

3M Related Literature

Listed below is related 3M technical literature that may be of interest. You may view and print these Bulletins from our Web site at www.scotchprint.com, or order them via our Fax-on-Demand (FOD) system. Call one of these phone numbers to order the desired bulletins, and specify the FOD document number provided in the chart.

United States or Canada: 1-800-364-0768
 International: 1-651-732-6506

Subject	Bulletin No.	FOD No.
Product Bulletins		
3M™ Scotchcal™ Overlamine 8519 and 8520	8519/8520	4524
Instruction Bulletins		
Making thermal ink jet graphics	4.23	6523
Application, substrate selection, preparation and substrate-specific application techniques	5.1	7001
Warranties		
Worldwide 3M™ MCS™ Warranty Packet (includes all Commercial Graphics MCS Warranties)		9503
Worldwide 3M™ MCS™ Warranty Overview-Folder		9504

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 Epson and Stylus Pro are trademarks of Epson.
 HP and DesignJet are tradenames of Hewlett Packard.
 Sintra is a trademark of Swiss Aluminum Ltd.
 Intron is a registered trademark of DuPont in the United States

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000, 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with blackbars in the margin.

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Product Bulletin 8522 - 3

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3M

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www.scotchprint.com

3M Canada
P.O. Box 5757
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Canada N6A 4T1
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HP and DesignJet are trademarks of Hewlett Packard.
Sintga is a trademark of Swiss Aluminum Ltd.
Imron is a registered trademark of DuPont in the United States

Bulletin Change Summary

The Epson Stylus Pro Printers 9500, 10000 10600, and Epson Archival Inks have been added to this bulletin. Additional changes resulting from this addition are marked with black bars in the margin.

3M México, S.A. de C.V.
Av. Santa Fe No. 55
Col. Santa Fe, Del. Alvaro Obregón
México, D.F. 01210
52-55-52-70-04-00
Fax: 52-55-52-70-22-77

3M Puerto Rico, Inc.
Puerto Rico Industrial Park
P.O. Box 100
Carolina, PR 00986-0100
787-620-3000
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Product Bulletin 8522 - 3



Scotchcal™

Opaque Imaging Media 8522

Description

This media is specially formulated to dry quickly after printing. Production of outdoor weatherable and long-term indoor durable graphics is now easier than ever. Its changeable adhesive allows easy removal for up to one year.

Advantages

- Optimized for use with selected Epson Stylus Pro printers and Epson Archival inks.
- Optimized for use with selected HP DesignJet Printers and HP DesignJet Ink System UV or HP83UV Color Ink System
- For making opaque, laminated graphics that are outdoor weatherable and long-term indoor durable
- Media:
 - For opaque (reflective) graphics
 - Changeable, easy to remove from warranted substrates up to 1 year later
 - Dries quickly after printing so the overlamine can be applied almost immediately
 - Low slippage paper liner for superior tiling
- Overlaminates:
 - Provide additional UV (ultraviolet) and physical protection for making weatherable finished graphics
 - Available in luster and matte gloss
 - Adhesive allows for heat-assisted or cold-temperature lamination

Applications and Uses

3M™ Scotchcal™ Changeable Opaque Imaging Media 8522 is intended only for ink jet printing and for use with the listed Compatible Products and Equipment and the following applications. Any other application is NOT warranted by 3M or covered by the worldwide 3M™ MCS™ Warranty unless 3M gives its prior written approval for the application.

- First surface images (the image is on top of the film) for opaque posters and signs, including:
 - Graphics for vans, personal vehicles, trucks and buses
 - Novelty posters
 - Retail and point-of-purchase displays
 - Information graphics such as maps and directories
 - Entertainment promotions in museums, zoos, parks, theatres, sports venues
 - Education and presentation graphics

Product Bulletin 8522

Release F, Effective January 2003
Black bar in margin indicates a change

- Legal and courtroom exhibits
- For flat or simple curved surfaces, with or without rivets, used in vertical ($\pm 10^\circ$) applications

Limitations of End Uses

The following uses and applications are specifically NOT warranted.

- Fleet applications in areas that use salt for winter road maintenance
- Application to non-warranted substrates, including wall-board
- Applications subjected to gasoline vapors or spills
- Application to corrugated or highly irregular surfaces or sharply raised areas
- Graphics applied to stainless steel, including stainless steel vehicles
- On flat surfaces with rivets, tenting of 4 to 10 mm around rivets may be expected; rivets may be cut around to eliminate tenting.

Note: Standard ink jet technology is water based. Water-based chemistry is susceptible to the extremes of heat and humidity. This is a factor in most product constructions on the market. Read the Fabrication, Shelf Life and Storage sections in this bulletin. Staying in the middle of these ranges always provides optimum performance.

Compatible Products and Equipment

Thermal Ink Jet Printing Systems

- Epson Stylus Pro 9500, Stylus Pro 10000 printer
 - Epson Archival Inks
- Epson Stylus Pro 10600 printer
 - Epson Archival Inks
- HP DesignJet Printers 2000 and 3000 series
 - HP DesignJet Ink System UV (pigment-based ink)
- HP DesignJet Printers 5000 series
 - HP83UV Color Ink System

Overlaminates (required)

- 3M™ Luster Overlamine 8519 (semi-gloss)
- 3M™ Matte Overlamine 8520

Receiving Report

Date: 9/6/4

Batch No: 1111954

Supplier: STUDIO VETERAIRE

Dart P/O: 8865

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☒ No ☐
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☒
 Shipment Complete: Yes ☒ No ☐
 QCC Inspection ☒ N/A ☐
 Work Order: 100 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Production/Admin:

Date

Received/Costing

Initial

Location



210 MAIN W.,
HAWKESBURY, ONT. K6A 2H6
Tel.: 613 632-2001
Fax: 613 632-9491
www.studiolettrage.com

INVOICE / FACTURE

VENDU À:
SOLD TO:

LIVRÉ À:
SHIPPED TO:

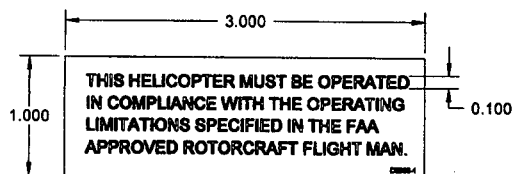
No.: 12184
DATE: 06/03/2009
PAGE 1 of 1
Re: Quote No. 7013

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury, Ontario K6A 1K7

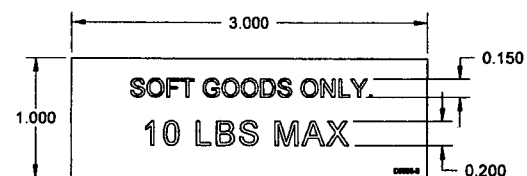
Dart Aerospace Ltd
Hawkesbury, Ontario

ITEM ARTICLE	QTY QYE	UNIT UNITÉ	DESCRIPTION	GST TPS	PST TVP	UNIT PRICE PRIX UNITÉ	AMOUNT MONTANT
	10 10 1		D39381P D39383P printing E - GST @ 5% G - GST @ 5%; PST @ 8% GST PST Exempt: #6122-5207	E E G		5.00 5.00 50.00	50.00 50.00 50.00 7.50
Studio de Lettrage GST: #869034676RP001 PO 8869 Sold By:						TOTAL	157.50

Merci! Thank You!



D3938-1 PLACARD



D3938-3 PLACARD

PRELIMINARY ISSUE

MP 09/05/06

W/O 48510

NOTES:

- 1) PLACARD TO BE WHITE LETTERING ON BLACK BACKGROUND
- 2) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED

A	NEW ISSUE	BY	09.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.07		

DART AEROSPACE LTD		REV. A
HAWKESBURY, ONTARIO, CANADA		
DRAWING NO.	D3938	SHEET 1 OF 1
TITLE	PLACARD	SCALE
		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 12:54:51 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLACARD

Job Number: 48510

Part Number: D39381

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/17 *JA*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-16

POSITIVE RECALL

EFFECTIVE

09/06/11

AUTH

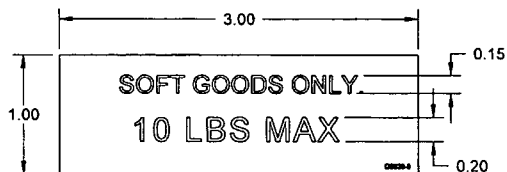
h

RELEASED

MF

DATE

09/06/12



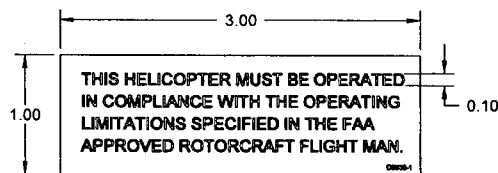
D3938-3 PLACARD

48510
RELEASED
2009-08-28
M

NOTES:

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
WHITE LETTERING ON BLACK BACKGROUND
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3938-3" USING 0.04 HEIGHT FONT
- 7) WEIGHT: 0.00 lbs

DESIGN	<i>KB</i>	DART AEROSPACE LTD	
DRAWN	KB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LLS</i>	DRAWING NO.	REV. B
MFG. APPR.	LL	D3938	SHEET 2 OF 2
APPROVED	<i>LL</i>	TITLE	SCALE
DE APPR.	<i>LL</i>	PLACARD	NTS
DATE	09.07.28	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D3938-1 PLACARD

48510

RELEASED
2009-08-28



NOTES:

- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
WHITE LETTERING ON RED BACKGROUND
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3938-1" USING 0.04 HEIGHT FONT
- 7) WEIGHT: 0.00 lbs

B	CHANGED BLACK BACKGROUND FOR D3938-1 PLACARD AND MOVED D3938-3 FROM SHEET 1.	KB	09.07.28
A	NEW ISSUE	KB	09.05.07
REV.	DESCRIPTION	BY	DATE
DESIGN	KB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KB		
CHECKED	LLS	DRAWING NO.	REV. B
MFG. APPR.	LL	D3938	SHEET 1 OF 2
APPROVED	LL	TITLE	SCALE
DE APPR.	LL	PLACARD	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/06/2009 12:54:51 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLACARD
Job Number	: 48510		
Estimate Number	: 14023		
P.O. Number	:	Part Number	: D39381
This Issue	: 11/06/2009 S.O. No. :	Drawing Number	: D3938 PRELIM
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : PURCHASED PARTS	Drawing Revision	: PRELIM
Previous Run	:	Material	:
Written By	:	Due Date	: 11/06/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>C 209/06/11</u>		
Comment	: Est Rev:A 09-06-10 New Issue DD verified by:EC		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8869C 209/06/11(10)

Make D3938-1 as per Dwg. Material: 3M 7mil masking film #8522CP or Avery IPM #2031

Material release note required

m 11954

2.0	D39381P	Placard
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Placard

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

ENGINEERING APPROVAL

W 09/06/12P 9/6/11 (12)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Ensure part as per Dwg D3483

ENGINEERING APPROVAL

W 09/06/12

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: 139C9/6/11(12)SP